

Work Order ID 66606

Tuesday, February 22, 2011 2:02:31 PM

**PRELIMINARY ISSUE**

Page 1

Item ID: D4334-3

Accept



Setup Start



Revision ID: PRELIM

Item Name: Base

Stop



Start Date: 2/23/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 2.00



Customer:

Reference:

11-02-22

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4334

PA5

PA4 11-02-22

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

MILL AS PER DWG
DWG REV: *PA4*

DEBURR

*11-02-23**2 0*

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*11-02-23**2 0*

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*J.F.S. 11/02/24**2 0*

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Page 2

Item ID: D4334-3

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Revision ID: PRELIM

Stop



Item Name: Base

Start Date: 2/23/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 BL 11-2-24

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M 11 02 24 25

170

Identify as per dwg & Stock Location: *Shel*

0.00



Packaging

Memo

0.00

Packaging

2 J 11.03.9

2 11/3/11 2/2

Work Order ID 66606

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Page 3

Item ID: D4334-3

Accept

Revision ID: PRELIM

Item Name: Base

Setup Start

Stop

Start Date: 2/23/2011 Start Qty: 2.00

Required Date: 2/25/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

C211103101

RD1370 mar

POSITIVE RECALL

EFFECTIVE 11/22/22 AUTH U

RELEASED _____ DATE _____

Picklist Print

Page 1

Tuesday, February 22, 2011 2:02:27 PM

Work Order ID: 66606



Parent Item: D4334-3



Parent Item Name: Base

Start Date: 2/23/2011

Required Date: 2/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-02-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			120	f	24.9275	0.208	0.437895			



6061-T6 Bar 1.25 x 1.25

Location

Loc Qty

Loc Code

MAT

17.633

116135

17.633

MAT03

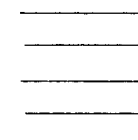
7.294450526

106259


7.06921053

110001

0.22524

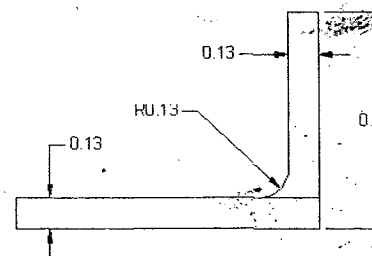
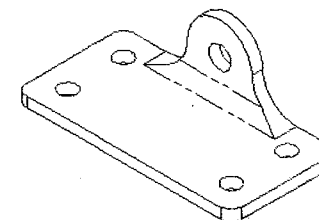
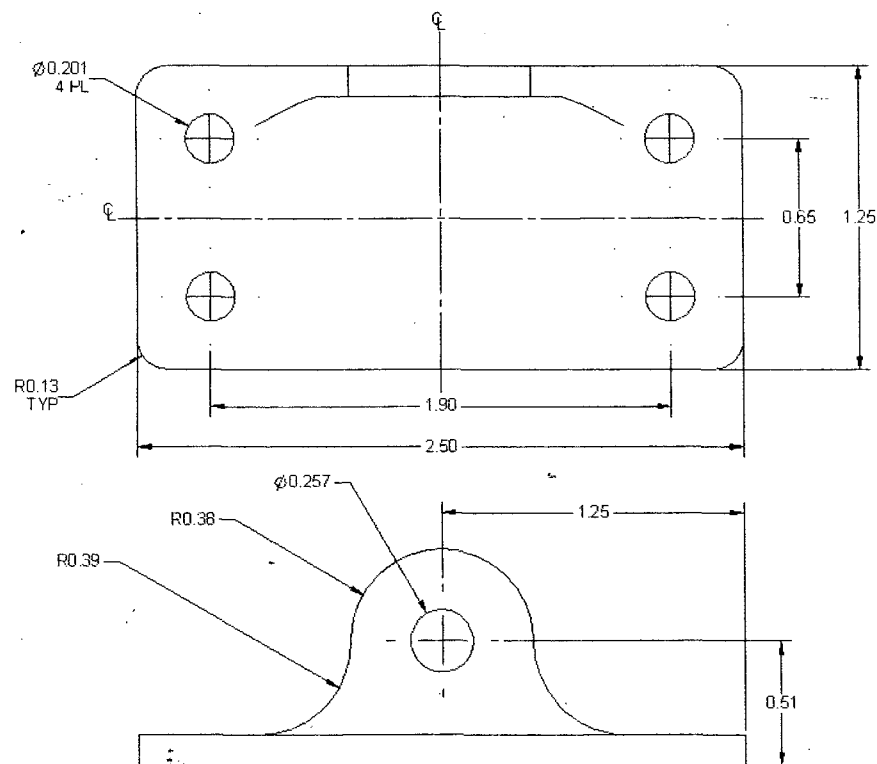


FIRST ARTICLE INSPECTION CHECKLIST

Measured by:		Audited by:	J.F.S.	Preliminary Approval:	
Date:	11-02-23	Date:	11/02/24	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15






66606

D4334-3 BASE

**PRELIMINARY
ISSUE**

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		D4334	SHEET 3 OF 4
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	BRACKET	NTS
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